

5124
DART AEROSPACE LTD

Work Order:

23353

Description: Console

Part Number:

D3363-1

Dwg: D3363 Rev. A B1 C1 05.05.16

Qty:

10

Ref:

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PA	05.05.20	10
2	PG	Issue P/O: 2008099 Email or Fax DXF file to vendor Laser Cut flat pattern per Dwg D3363 Possible Supplier: Industrial Laser Material release note is required	LN	05.05.24	10
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	CL	05/06/30	10
4	QC6	Inspect dimensions as per Dwg D3363	PA	0507-29	10
5	GA	Deburr	SAD	05/07/12	10
6	GA	C'sink rivet holes-as-per Dwg D3363			
7A	GB	Form as per Dwg D3363	Z	05-08-09	10
8	QC5	Inspect work to Step 7	SB	05/08/24	10
9	ST	Identify and Stock	CL	05/08/26	10
10	AC	Cost / part: 90.84	SAC	05.08.29	10
11	DC	Close W/O 90.84 Inspect Level 21	Z	05/08/29	10

Rev	Date	Change	Revised By	Approved
A	05.04.11	New issue	KJ/JLM	

RELEASED
05/04/12

7B	WA	Weld as per Dwg D3363: Part QSI004	CPL	05.08.25	10
7C	QCS QCS9	Inspect Weld	Z	05-08-25	10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
050612	6	This step should be on the assembly w/o permanent change	<i>[Signature]</i>			<i>[Signature]</i> 05-06-12	<i>[Signature]</i> 05-06-12	
05-08-24	7	Add Steps as shown	<i>[Signature]</i>				<i>[Signature]</i> 05-08-24	

05-08-24 6 ~~Remove~~ change weld symbol to both sides and remove all around (i.e. *[Diagram]*) PH
(PERMANENT CHANGE) 05-08-24

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/08/24

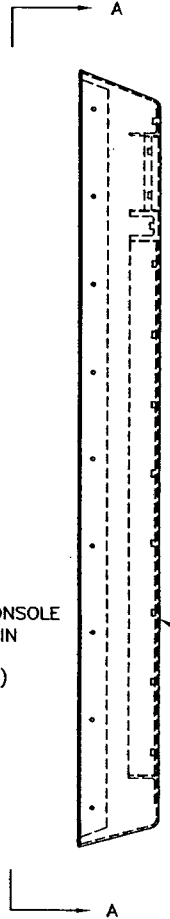
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

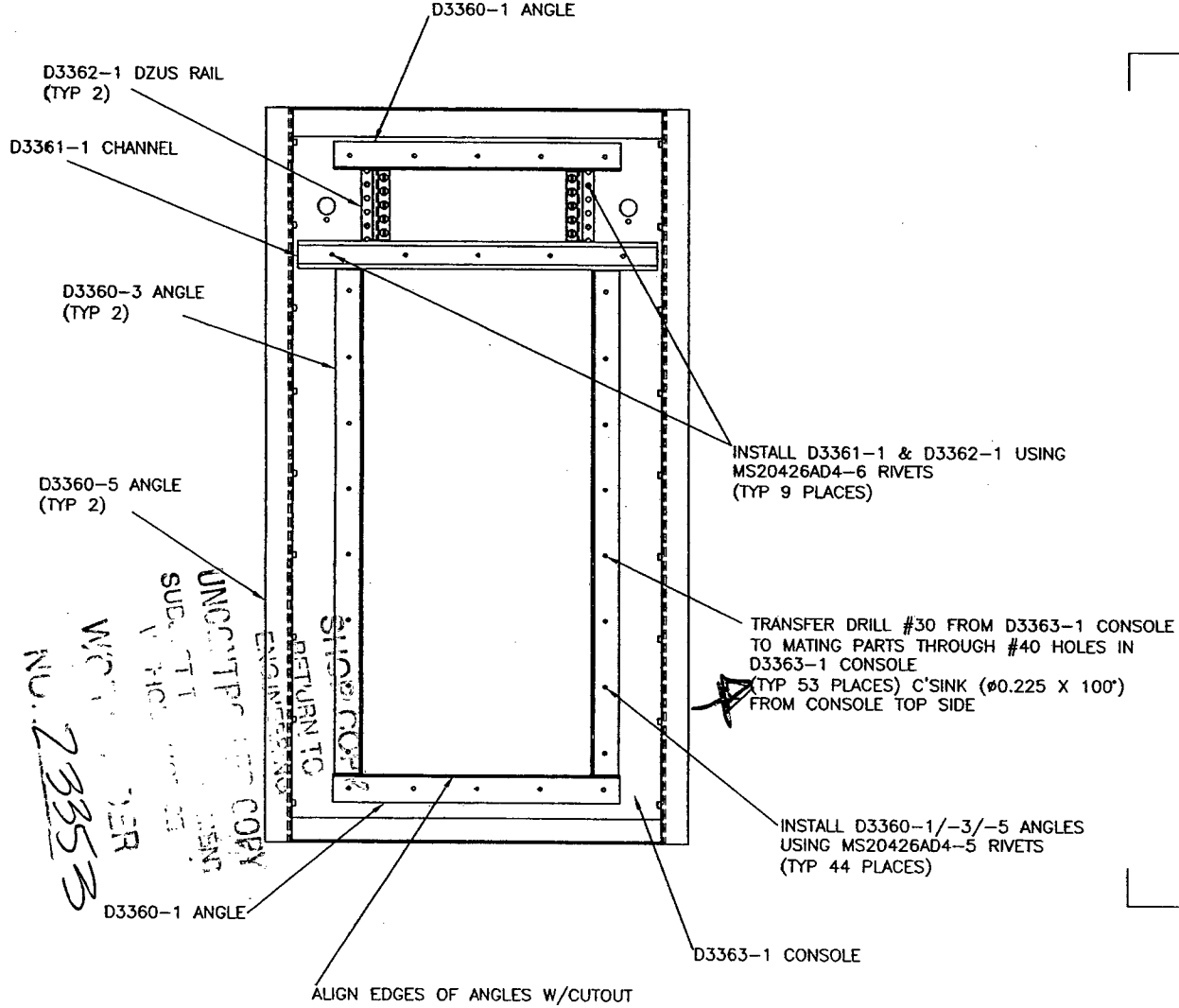
DART

RELEASED
05.03.31

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	SHEET 1 OF 3
DATE	05.03.28	TITLE	D3363	CONSOLE ASSEMBLY	SCALE 1:5
A	04.11.29	NEW ISSUE			
B	05.03.28	INCREASE WIDTH BY 0.125			
B1	05.04.28	CHANGE WIDTH TO 10.430, WAS 10.43			



C'SINK
THIS SIDE
(REF)



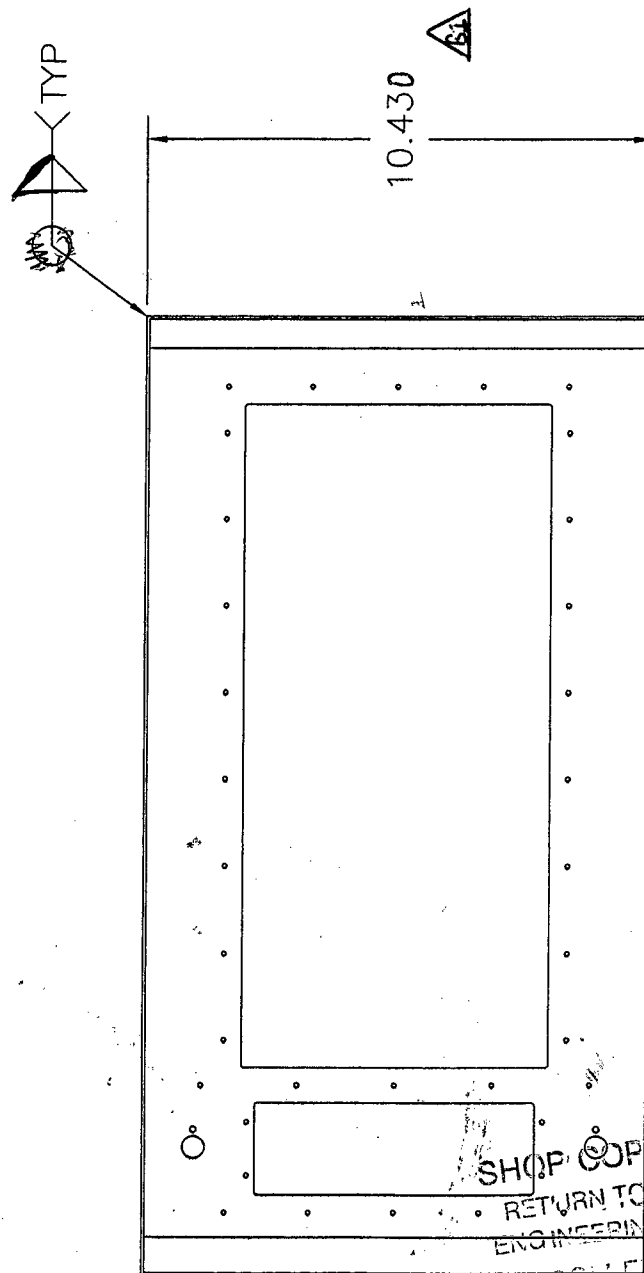
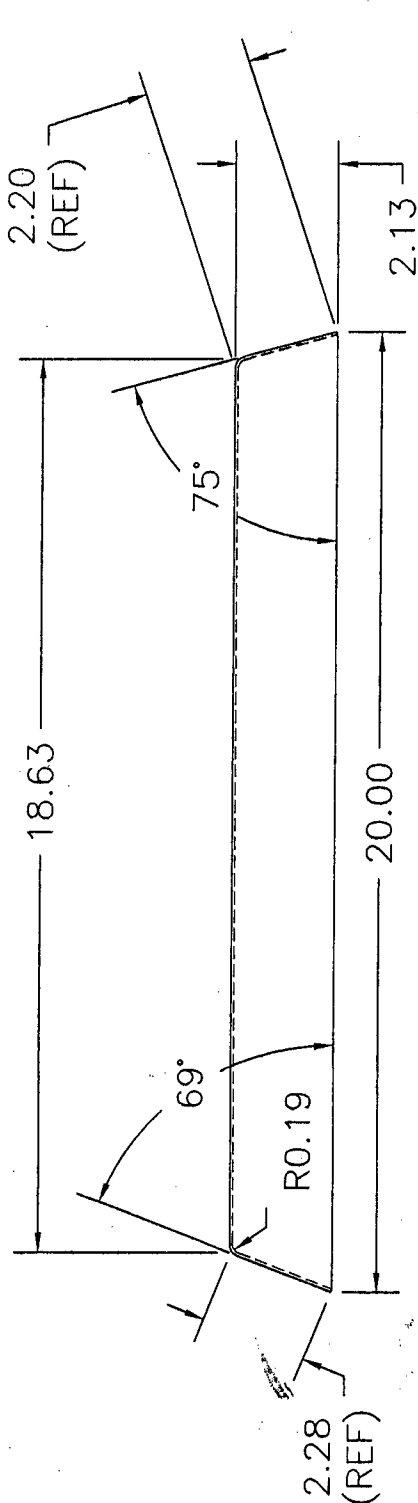
PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

VIEW A-A FROM UNDER CONSOLE ASSEMBLY

- D3363-041 CONSOLE ASSEMBLY**
- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
 - 3) FINISH:ACID ETCH AND ALODINE PER DART QSI 005 4.1



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3363	REV. B SHEET 2 OF 3
DATE 05.03.28	TITLE CONSOLE ASSEMBLY		SCALE 1:4



D3363-1 BEND DETAIL

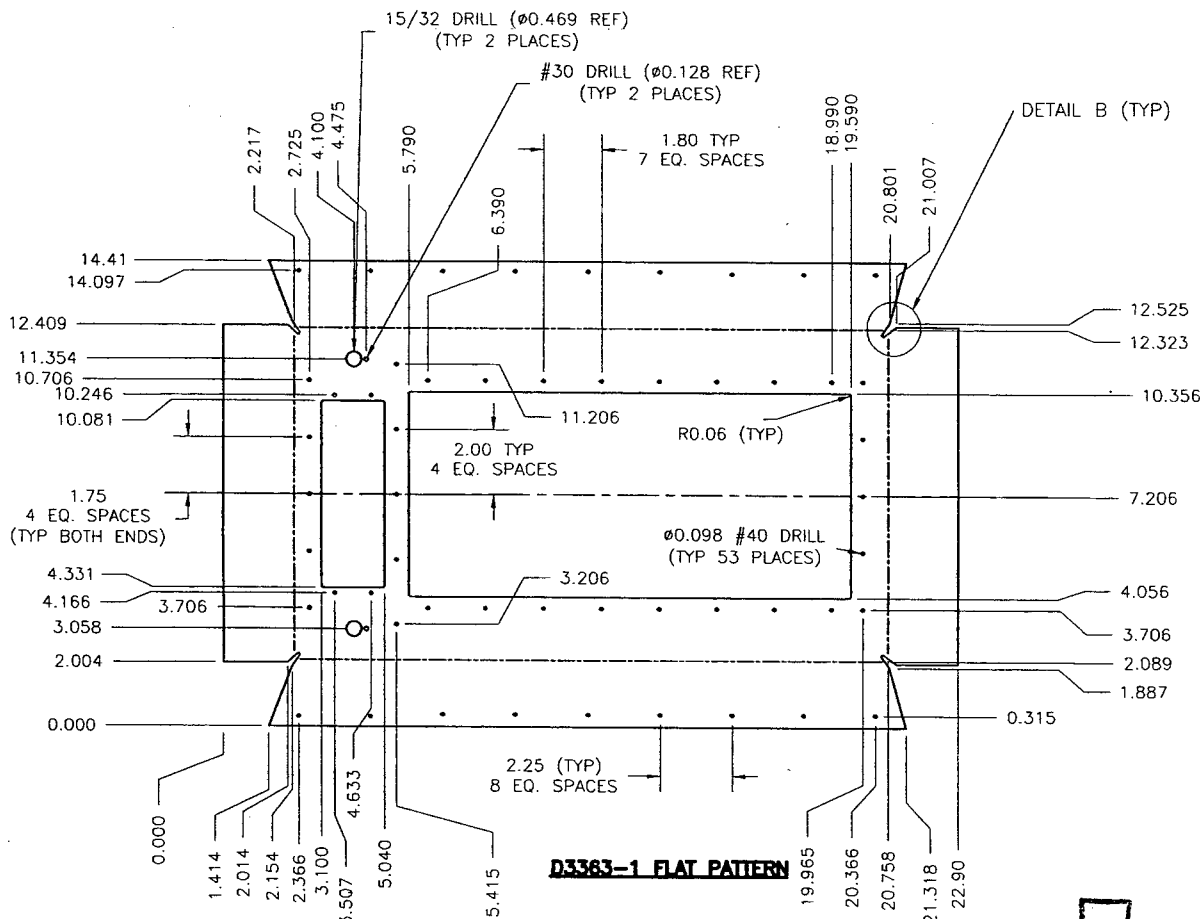
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23353

RELEASED
05-03-31

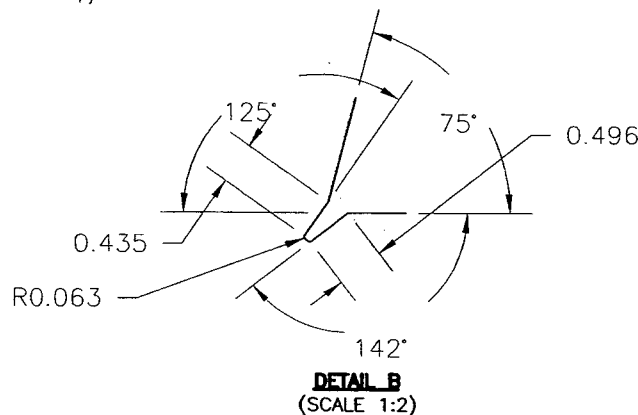
- D3363-1 CONSOLE
- 1) WELD PER DART QSI 004
 - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
PH	PH	DRAWING NO.	REV. B	
CHECKED	APPROVED	D3363	SHEET 3 OF 3	
DATE		TITLE	SCALE	
05.03.28		CONSOLE ASSEMBLY	1:6	



D3363-1 FLAT PATTERN



DETAIL B

(SCALE 1:2)

D3363-1 CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (MATERIAL SPEC: QQ-A-250/11) 0.063 THICK (REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

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SUBJECT TO
V. H.C.
W. H. CORDER
NO. 23353

RELEASED
05.03.31

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 17, 2005
10:51 am

Work Order No : 0023353
Project Name : D3363-1
Project For : WK524
Work Order Type : Main
Main WO Number :
House Part Number : D3363-1
Description : Console
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-17-05
Est Finish Date : 06-22-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Integris Metals

8/18/2004 8:53

PAGE 001/002

Fax Server

A N A G F o l l i n g G m b H

Zertifiziert nach ISO 9001, ISO/TS 16949, ISO 14001, ENAS-VO
A B N A M E P R O F Z E U G N I S EN 18204 3.1.9
INSPECTION CERTIFICATE - MILL TEST CERTIFICATE

Seite/Page 1
Datum/Date 2004 03 11
OS-NUMMER 85627558
Certificate No.

Commonwealth Metal Corporation
Div of Commercial Metals Comp.
PO Box 1426
ENGLEWOOD CLIFFS NJ 07632-3139
USA

Kd-Bestellnr. / Order No. 4341-12858-4-13
Bestellvers. / Order Remarks
Datum/Date 2003 12 22
AFW-AB-Nr. / Order Confirmation No. 535729
Datum/Date 2004 01 13
Lieferschein Nr. / Delivery Note 85627558
Datum/Date 2004 03 16

Endkunde, Bestellnr. / Your Customer, Order No.

Markierungen, Stempelungen / Mark. Stamp

Integris Metals

Produkt / Product

Techn. Lieferbedingungen/Techn. Specification

6061
coil

ASTM B 209-02a, AMS-QQ-A-250/11-97,
ASME SB-209-01

Re. / AB-Pos. / Bestell-Abmess. (inch) / Po. / Ord. Po. / Order Dimensions	B-Nr. / Ls / TL / Guss Nr. / Lot-No. / Part / Cast No.	Zustand / Temper	Bemerkungen / Remarks	Kolle / Gew. (lb) / Stk. Packing Weight / Pos.
01 / 02/01 / 0.083x 48.00	47973/01	5319 T6		0020 / 7445.. / 1
01 / 02/01 / 0.063x 48.00	47973/02	5319 T6		0022 / 7863.. / 1
01 / 02/01 / 0.063x 48.00	47973/03	5320 T6		0023 / 7281.. / 1
02 / 01/01 / 0.125x 48.00	47957/01	5314 T6		0015 / 7740.. / 1
02 / 01/01 / 0.125x 48.00	47957/03	5316 T6		0016 / 7855.. / 1
02 / 01/01 / 0.125x 48.00	47957/02	5314 T6		0017 / 7907.. / 1

Chemische Zusammensetzung (Ch.-Analysen Barrerherst., Gew. %) / Chemical Composition (Rest-A1)

Guss Nr. / Cast No.	ANAG / Code	SI	FE	CU	MN	MG	CR	ZN	TI	PB	BI	NI	SR
5314	6061.1	0.66	0.43	0.23	0.12	0.89	0.17	0.02	0.06	<0.005	<0.005	<0.005	<0.005
5316	6061.1	0.70	0.42	0.24	0.13	0.89	0.17	0.04	0.05	<0.005	<0.005	0.01	<0.005
5319	6061.1	0.64	0.40	0.22	0.11	0.86	0.16	0.04	0.06	<0.005	<0.005	<0.005	<0.005
5320	6061.1	0.68	0.44	0.21	0.12	0.94	0.18	0.05	0.05	<0.005	<0.005	0.01	<0.005

Mechanische Eigenschaften / Mechanical and other Properties (A.E.N-Diff.Pos.)

B-Nr. / Ls / Lot-No. / (Pos.)	Cast No.	Direction / (°)	Rm / ksi	Rp0.2 / ksi	A2 / %	Brügeltest / Bend Test
47957/01 A		90	46.8	37.6	18	(ok)
47957/01 E		90	47.3	38.4	17	(ok)
47957/02 A		90	46.6	37.1	18	(ok)
47957/02 E		90	46.7	36.8	17	(ok)
47957/03 A		90	47.3	38.1	18	(ok)
47957/03 E		90	47.9	38.9	19	(ok)
47973/01 A		90	47.3	39.3	15	(ok)
47973/01 E		90	47.0	38.6	15	(ok)
47973/02 A		90	47.3	39.5	14	(ok)
47973/02 E		90	47.1	39.0	15	(ok)
47973/03 A		90	47.1	39.2	15	(ok)

0.063 6061 T6 Alum.

A M A G r o l l i n g G m b H

Seite/Page 2
Datum/Date 2004 03 11

Zertifiziert nach ISO 9001, ISO/TS 16949, ISO 14001, ENAS-VO
ABNAHMEPRÜFZEUGNIS EN 10204 3.1.B
INSPECTION CERTIFICATE - MILL TEST CERTIFICATE

QB-MÜNNER 85627558
Certificate No.

Mechanische Eigenschaften				Mechanical and other Properties (A,E,M-Diff.Pos.)			
B-Nr./Los	Direction	Rm	Rp0.2	A2°	Biegetest		
Lot-No./Pos.)	Cast No.	ksi	ksi	%	Band Test		
47973/03 E	90	46.7	38.6	15	(ok)		

Material meets also the requirements of AMS 4027H, but not marked.

Es wird bestätigt, dass die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellung entspricht.
We hereby certify that the material described above has been tested and complies with the terms of the order contract.

Ranshofen, am 2004 03 11
Postfach 32

Qualitätsmanagement/Quality Management: KLANFER
A 5282 Ranshofen Tel.: +43(7722)809-2746

FAX: +43(7722)809-442

AMAG rolling
Werksachverständiger
ROL-Nr. 015

0.063 6061 FG Alu